

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027951**Date Inspected:** 11-Jul-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** jobsite

CWI Name:	Fred Michaels/William Sherwood			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	OBG		

Summary of Items Observed:

At the start of the shift this Quality Assurance Inspector (QA) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) welding and Quality Control (QC) personnel. The observations and inspections were performed as noted below:

This QAI observed Welder Steve Davis (ID#7889) using a rosebud torch to preheat splice 12W-W2.1-C1 to a QC recorded, QA verified temperature of 150F. Preheat temperature was measured using a Tempil Stick. This QAI noted QC Tony Sherwood recording preheat temperature whenever there was a stop in work.

QAI witnessed the welding of 12W-W2.1-C1 by welder Steve Davis utilizing the Shield Metal Arc Welding Process in the 1G position using E7018 consumable electrodes. The QC recorded and this QAI verified that the weld metal was being deposited to the parameters of Welding Procedure Specification ABF-WPS-D15-1040C-CU.

Welder Davis was observed using the stringer method and good workmanship practices in regard to interpass cleaning.

This QAI observed Welder Jin Pei Wang (ID#7299) using a rosebud torch to preheat splice 12W-W2.1-C1 to a QC recorded, QA verified temperature of 150F. Preheat temperature was measured using a Tempil Stick. This QAI noted QC Tony Sherwood recording preheat temperature whenever there was a stop in work.

QAI witnessed the welding of 12W-W2.1-C1 by welder Jin Pei Wang utilizing the Shield Metal Arc Welding Process in the 1G position using E7018 consumable electrodes. The QC recorded and this QAI verified that the weld metal was being deposited to the parameters of Welding Procedure Specification ABF-WPS-D15-1040C-CU.

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Welder Wang was observed using the stringer method and good workmanship practices in regard to interpass cleaning.

This QAI observed Welder Xiao Jian Won (ID#9677) using a rosebud torch to preheat splice 12W-W2.1-C1 to a QC recorded, QA verified temperature of 150F. Preheat temperature was measured using a Tempil Stick. This QAI noted QC Tony Sherwood recording preheat temperature whenever there was a stop in work.

QAI witnessed the welding of 12W-W2.1-C1 by welder Xiao Jian Won utilizing the Shield Metal Arc Welding Process in the 1G position using E7018 consumable electrodes. The QC recorded and this QAI verified that the weld metal was being deposited to the parameters of Welding Procedure Specification ABF-WPS-D15-1040C-CU.

Welder Wang was observed using the stringer method and good workmanship practices in regard to interpass cleaning.

QAI witnessed the welding of 12W/13W-B1 by welder Jason Collins utilizing the Shield Metal Arc Welding Process in the 3G position using E7018 consumable electrodes. The QC recorded and this QAI verified that the weld metal was being deposited to the parameters of Welding Procedure Specification ABF-WPS-D15-1040C-CU.

Welder Won was observed using the stringer method and good workmanship practices in regard to interpass cleaning.

This QAI performed Magnetic Particle Testing on Deck Splice 13W-123.6 at a specified frequency of 10% of the total length of weld. No indications were noted. Please see Magnetic Particle Testing report dated 7/11/12 for further details.



Summary of Conversations:

There were general conversations with Quality Control Inspector Fred Michaels, at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift. All observations were relayed to Bill Levell.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510 385 5910, who represents the Office of Structural Materials for your project.

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Inspected By: Daggett,Matt

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer